

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017984**Date Inspected:** 06-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

ZPMC SHIP # 19 (10AW)

This QA Inspector along with Mr. Manoj Prabhune photographed and documented at various locations on OBG 10AW prior to the shipment of (Voyage 6) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 10AW (Panel Point 86.5 thru Panel point 88) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 10AW – PP 86.5and PP 87.5.
2. Corner Assembly – Crossbeam side of segment 10AW – PP 87 and PP 88.
3. Longitudinal Diaphragm - Crossbeam side of segment 10AW – PP 87 and PP 88.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 10AW – PP 87 and PP 88.
5. Sea fasteners- 10AW – PP 87 and PP 88.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 10AW – PP 87 and PP 88.
7. Longitudinal Diaphragm – Bike path side of segment 10AW – PP 87 and PP 88.
8. Corner Assembly – Bike path side of segment 10AW – PP 87 and PP 88.
9. Truss post – Bike path side of segment 10AW – PP 86.5and PP 87.5.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ZPMC SHIP # 19 (10BW)

This QA Inspector along with Mr. Manoj Prabhune photographed and documented at various locations on OBG 10BW prior to the shipment of (Voyage 6) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 10BW (Panel Point 88.5 thru Panel point 91) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 10BW – PP 88.5, PP 89.5 and PP 90.5.
2. Corner Assembly – Crossbeam side of segment 10BW – PP 89 to PP 91.
3. Longitudinal Diaphragm - Crossbeam side of segment 10BW – PP 89 to PP 91.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 10BW – PP 89 to PP 91.
5. Sea fasteners- 10BW – PP 89 to PP 91.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 10BW – PP 89 to PP 91.
7. Longitudinal Diaphragm – Bike path side of segment 10BW – PP 89 to PP 91.
8. Corner Assembly – Bike path side of segment 10BW – PP 89 to PP 91.
9. Truss post – Bike path side of segment 10BW – PP 89 to PP 91.

ZPMC SHIP # 19 (Lift 10W)

This QA Inspector witnessed the final tension verification on the wire rope for the cable tray connected diagonally by Crosby forged wire rope clips. The QA inspector observed the tensioning of the wire rope appeared to be in general compliance with the Request for Information (RFI) No. ABF-RFI-001874R00 dated. August 27, 2009. The segment and panel point designations were as follows:

10AW – PP 85.5-PP 86 and PP 87-PP 88
10BW – PP 89-PP 90 and PP 90-PP 91
10CW – PP 91.5-PP 92 and PP 92-PP 93

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (11BE-11CE)

This QA inspector along with QA inspector Mr. Manjunath S Math performed dimensional joint survey inspection on the WT stiffener to verify the vertical and horizontal offset. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11BE to Segment 11CE

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
